

Work Order ID 58341



Page 1

Monday, May 03, 2010 2:57:02 PM

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 5/3/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/12/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: MUF Date: 10-5-3 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3910	B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

10/05/05

50 0

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: B

DWG REV: B

0.00

10/05/08

49 2

110

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____



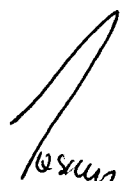
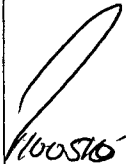
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3910-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: _____ Date: 10/05/10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/05/12

NCR: 58341		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/10	110	With 4.45 is 4.38 because stock material was too small RC: Encl piece of bar/material	 10/05/12	Scrap x 1 - no replace.	MW 10/05/10	 10/05/10	 10/05/12	 10/05/10

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

MV= 10/05/08

49 1

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ant 10/05/10

49 1

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

HA BL 10-5-10

W/O:		WORK ORDER CHANGES					
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Start Date: 5/3/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/12/2010 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

el

10/05/11

Memo

START: 8:00am
Temp: 320°F
Fin: 8:30am

0.00

49

Ø

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

49 BR 10-5-11

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

P10/5/11 (49)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/12

10-5-11
49

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 2:57:01 PM

Page 1

Work Order ID: 58341



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 5/3/2010

Required Date: 5/12/2010

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	513.2589	0.13			



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

513.2589

43722

180

→ 45800

333.2589

→ 6.844 ml 10/05/05

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order: 58341
Description: Crosstube Lug		Part Number: D3910-1
Inspection Dwg: D3910 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	±.03	4.453	✓			
1.38	±.03	1.38	✓			
.735	±.010	.727	✓			REF
.31	±.03	.30	✓			
.375	±.010	.373	✓			
.375	±.010	.374	✓			
.625	±.010	.622	✓			
3.700	±.010	3.699	✓			
Ø .257	+0.006 -0.001	.259	✓			
2.20	±.03	2.20	✓			
.625	±.010	.623	✓			
.38	±.03	.375	✓			
.375	±.010	.375	✓			
Ø .191	+0.005 -0.001	.196	✓			2 PL

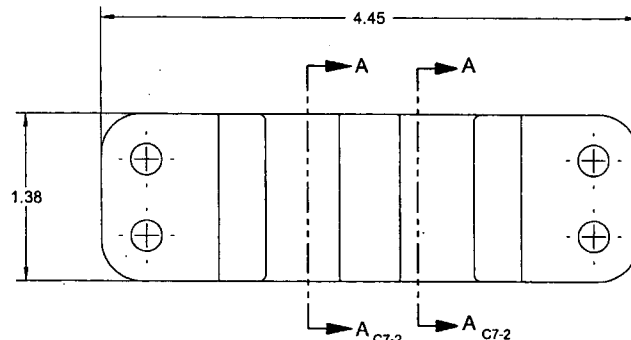
Measured by: MW	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10/05/08	Date: 10/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

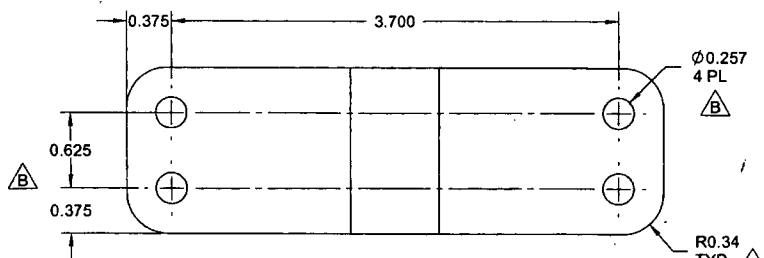
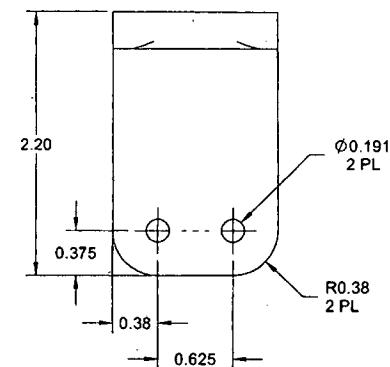
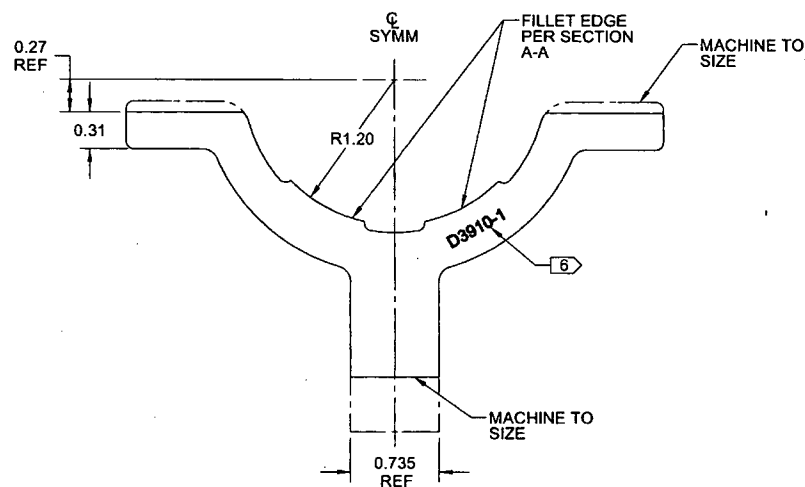


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



#58341



D3910-1 X-TUBE LUG

RELEASED
2010-03-22
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	AS	DRAWING NO. D3910	REV. B
MFG. APPR.		TITLE X-TUBE LUG (350)	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

W/O:		WORK ORDER CHANGES					
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